

Work Order ID 78553

78553

U/R

Page 1

January-11-12 10:55:40 AM

Item ID: D412-742-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: UR OK 12/01/11 Stop *NS2*
 Item Name: Float Skidtube Installation
 Start Date: 11/01/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: M.C.5 Date: 12/01/11 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9517	B
IIN D412-742	E

100 DOCUMENT CONTROL sl 0.00
 100
 DC Memo 0.00
 Document Control Photocopy bluefile and create labels per PPP D412-742-013 CHG007 S. 12/02/12

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging 12/2/12 sf

B 79956

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78553

78553

Page 2

January-11-12 10:55:40 AM

Item ID: D412-742-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Float Skidtube Installation
 Start Date: 11/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-742-013 Location: _____	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL

EFFECTIVE 12.02.28 AUTH CP
 RELEASED CP DATE 12.02.28
 Add DSI FROM CP

MF
12-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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10

Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A05.10.13New Issue KJ/JLM
 IPP Rev:B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN 1072 DD verified by:JLM
 IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC
 IPP Rev:E 09-01-23 as per DSI9441 DD verified by:EC IPP RevF: add AN4C7A DD 10.01.13 verified by:EC IPP Rev:G 11.11.01 as per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D412-742-043

Manufactured No

110

Each

0.0000

1

1

D412-742-043

Replacement Float Skidtube

**

B 79956^d* SP

D2571

Manufactured No

110

Each

9.0000

1

1

D2571

Saddle, Fwd Out 205

**

B 794255

Location

Loc Qty

Loc Code

ST425

-11

76438

1

ST433

20

77446

8

D2572

Manufactured No

110

Each

2.0000

1

1

D2572

Saddle, Fwd In 205

**

79978 C 12/20

Location

Loc Qty

Loc Code

ST433

2

71107

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2573 Manufactured No

110 Each 1.0000 1 1

D2573

Saddle, Aft Out 205

**

B78236

[Handwritten signature]

Location

Loc Qty

Loc Code

ST423

-12

ST434

13

77287

1

D2574 Manufactured No

110 Each 1.0000 1 1

D2574

Saddle, Aft In 205

**

B79423

[Handwritten signature]

Location

Loc Qty

Loc Code

ST434

1

77286

1

D2876 Manufactured No

110 Each 57.0000 2 2

D2876

Saddle Spacer

**

57

[Handwritten signature]

Location

Loc Qty

Loc Code

ST025

57

76949

57

D2877 Manufactured No

110 Each 57.0000 2 2

D2877

Saddle Spacer

**

12/2/22

[Handwritten signature]

Location

Loc Qty

Loc Code

ST020

57

73309

7

77052

50

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3403-1 Manufactured No

110 Each

40.0000 8 8

D3403-1

Bushing

**

B80208

h

Location

Loc Qty

Loc Code

ST041

40

70696

15

76213

25

D3403-5 Manufactured No

110 Each

0.0000 8 8

D3403-5

Bushing

**

B794405

h

D2747 Manufactured No

110 Each

166.0000 4 4

D2747

Set Screw

**

sp

h

Location

Loc Qty

Loc Code

ST017

166

77484

166

D3533-1 Manufactured No

110 Each

54.0000 2 2

D3533-1

Set Screw

**

4
2
12/2/22

sp

h

Location

Loc Qty

Loc Code

ST054

54

73310

4

77611

50

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C6A Purchased No

110 Each 364.0000 16

AN4C6A

Bolt

**

Location Loc Qty Loc Code

FG 4

103344 4

ST356 360

116704 8

119328 152

119749 200

AN4C53A Purchased No

110 Each 21.0000 4

AN4C53A

Bolt

**

Location Loc Qty Loc Code

ST361 21

119688 1

119861 20

AN4C52A Purchased No

110 Each 87.0000 4

AN4C52A

BOLT

**

Location Loc Qty Loc Code

ST361 87

117688 7

118451 30

119641 50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12.02.28		Acceptable to replace Qty(4) AN4CS3A BOLT WITH Qty(4) AN4CS2A BOLT M119641 8.12.28	GP			GP 12.02.28 051042	S 12/02/28	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C12A

Purchased

No

110

Each

118.0000

8

8

AN6C12A

BOLT

**

Location

Loc Qty

Loc Code

ST341

118

119749

43

119862

75

D3672-3

Manufactured

No

110

Each

868.0000

32

32

D3672-3

Phenolic Washer

**

Location

Loc Qty

Loc Code

ST074

868

64176

180

73487

188

76278

500

AN960C416L NAS1149C0432R

Purchased

No

110

Each

0.0000

32

32

AN960C416I

WASHER

**

D3672-9

Manufactured

No

110

Each

184.0000

8

8

D3672-9

Phenolic Washer

**

Location

Loc Qty

Loc Code

ST074

184

35523

184

NAS1149C0632R

Purchased

No

110

Each

145.0000

8

8

NAS1149C0632R

WASHER

**

Location

Loc Qty

Loc Code

ST297

145

118006

45

119736

100

January-11-12 10:55:44 AM

Shop Packet Print

Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-11

Manufactured No

110

Each

551.0000

8

8

**

D3672-11

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

551

58046

51

77483

500

110

Each

1,038.000

29

29

**

MS21043-4

Purchased

No

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

528

119309

32

119546

496

110

Each

28.0000

8

8

**

D3403-3

Manufactured

No

D3403-3

Bushing

Location

Loc Qty

Loc Code

ST042

28

76215

28

110

Each

8.0000

1

1

**

D3405-041

Manufactured

No

D3405-041

Lug Assembly

Location

Loc Qty

Loc Code

ST478

8

62227

2

77000

6

January-11-12 10:55:44 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3405-043 Manufactured No

110 Each

12.0000

1 1

D3405-043

Lug Assembly

**

B776855

Location

Loc Qty

Loc Code

ST423

2

65703

2

ST474

10

76999

10

AN4C7A

Purchased No

110 Each

279.0000

4

AN4C7A

Bolt

**

4

Location

Loc Qty

Loc Code

ST356

279

109147

279

D3407-041

Manufactured No

110 Each

0.0000

1

D3407-041

Tow Ring

**

4

D3417-3

Manufactured No

110 Each

48.0000

2

D3417-3

Washer

**

2

Location

Loc Qty

Loc Code

FG

9

33519

9

ST042

39

53182

15

66847

24

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

75.0000

1

D3456-1

Washer

**

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

50

77486

50

ST044

18

66848

3

71165

2

73493

13

AN3C37A

Purchased

No

110

Each

128.0000

1

AN3C37A

BOLT

**

Location

Loc Qty

Loc Code

ST354

128

116874

11

117010

2

118709

50

119324

25

119531

40

AN3C40A

Purchased

No

110

Each

67.0000

1

AN3C40A

BOLT

**

Location

Loc Qty

Loc Code

ST354

67

112454

17

114442

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-11-12 10:55:44 AM

Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C41A

Purchased

No

110

Each

162.0000

1

1

**

AN3C41A

BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

158

119324

48

119530

60

119673

50

AN3C42A

Purchased

No

110

Each

49.0000

1

1

**

AN3C42A

BOLT

Location

Loc Qty

Loc Code

ST354

49

106176

1

117763

3

118131

20

119673

25

AN3C43A

Purchased

No

110

Each

39.0000

4

4

**

AN3C43A

BOLT

Location

Loc Qty

Loc Code

ST354

39

114455

8

118387

6

119673

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78553

78553

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C46A Purchased No

110 Each 87.0000 5 5

AN3C46A

BOLT

**

Location

Loc Qty

Loc Code

ST355

87

118758

17

119673

50

119861

20

AN960C10L NAS1149C0332 Purchased No

110 Each 0.0000 26 26

***AN960C10I ***

washer

**

MS21043-3 Purchased No

110 Each 1,273.000 13 13

MS21043-3

Nut

**

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

662

119901

662

ST301

539

118077

2

118614

441

118686

30

119758

66

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

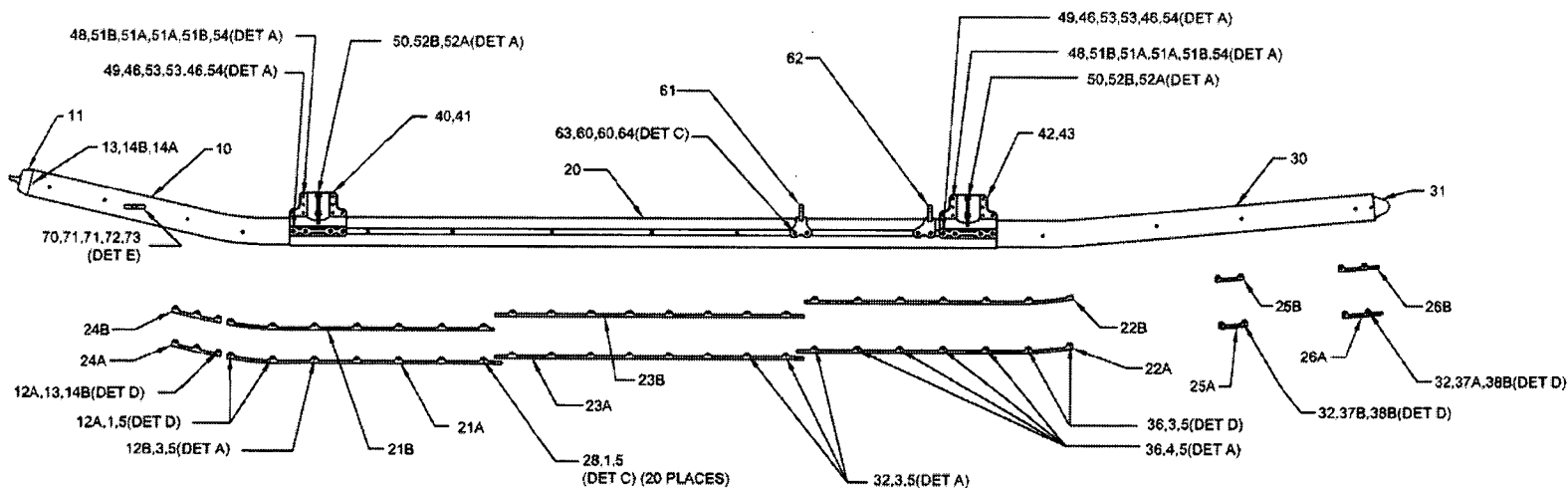
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED C
SUBJECT TO AMENDM
WITHOUT NOTICE
WORK ORDER
NO. 78553 M.C.J
12/01/11



**FIGURE 4 – D412-742-013 FLOAT SKIDTUBE INSTALLATION
(APICAL TRI-BAG COMPATIBLE)**

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Revision: **D**
Date: 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

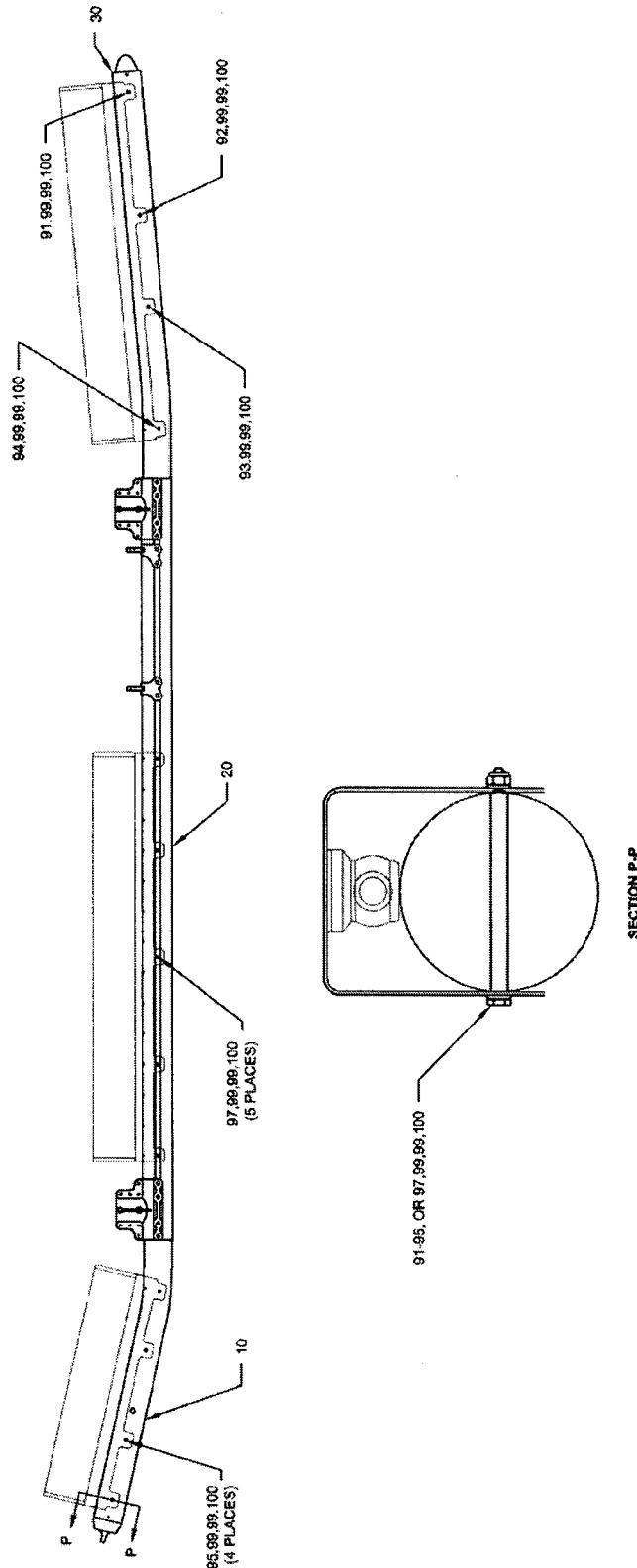
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

70553



**FIGURE 5 – D412-742-013 FLOAT BAG ATTACHMENT BOLTS AND LOCATIONS
(APICAL TRI-BAG COMPATIBLE)**

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Revision: **D**
Date: 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7853

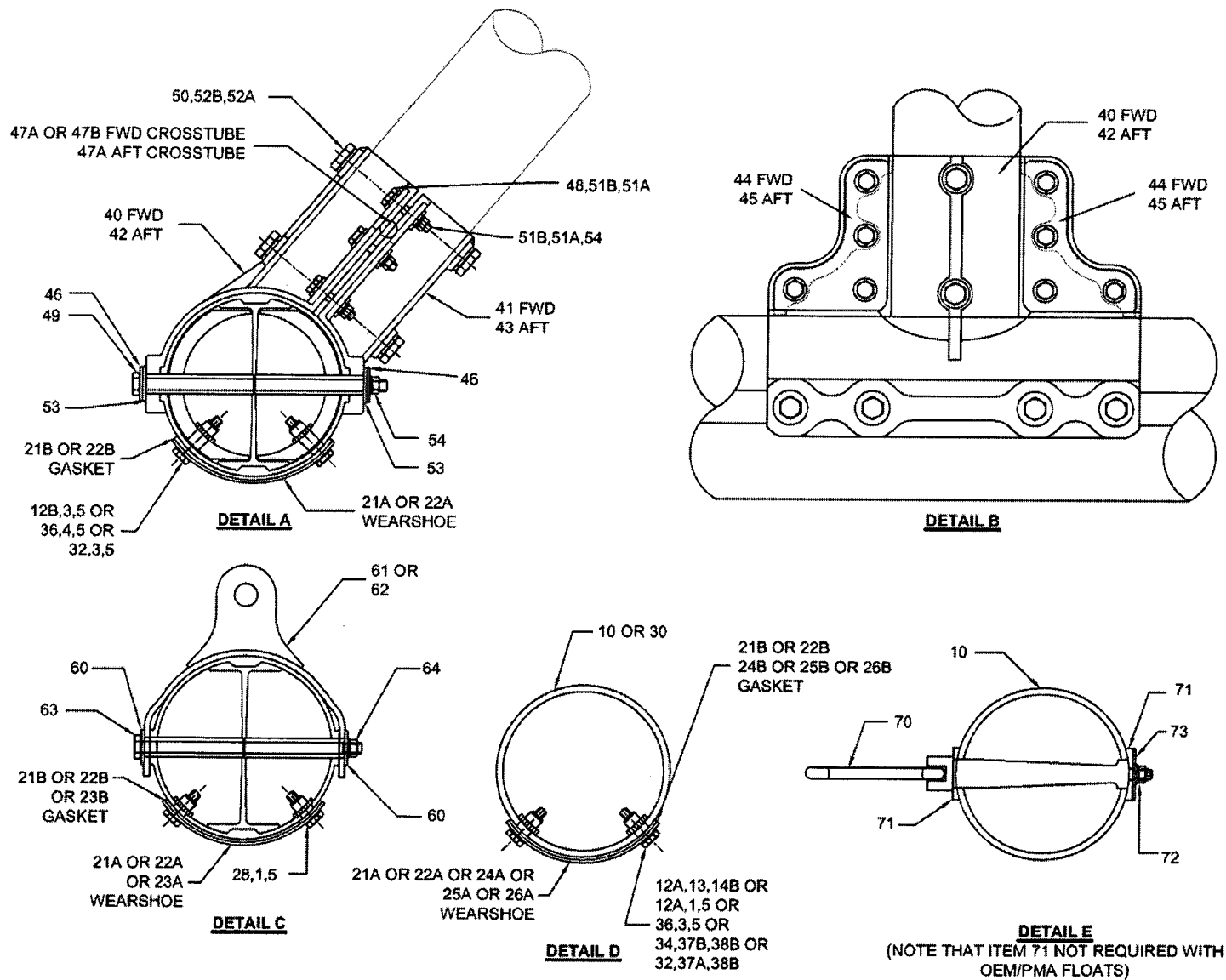


FIGURE 6 - D412-742-011/-013 DETAILS

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Revision: D

Date: 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries